Work Ord e Friday, June 04,										1		Page 1
Item ID: Revision ID:	D3911-3		A	Accept				s s	etup	Start		
Item Name: Start Date: Required Date:		Start Qty: 20.00 Req'd Qty: 20.00	MF 1811 1811 1811 1811 1811 1811 1811 1811 1811 1811 1811 1811 1811 1811 1811 181 1811 1811 1811 1811 1811 1811 1811 1811 1811 1811 1811 1811 1811 1811 1811 181		Cust Item I Customer:	D:				Stop		
Reference: Approvals:	Process Plan QC:	:_/	Date:	Tooling: SPC (Y/N):		ate:	1	R	Run	Start Stop		1 1 1 1 1 1 1 1 1 1
Sequence ID/ Work Center II		Operation Description	•	Set Up/ Run Hours	Tool ID		Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revis	ion Nbr										÷
D3911	С											
100 Bandsaw Jeaspa Bandsaw		Memo	o 2.885" long	0.00 0.00 LF1	p/66/08			10		<i>y</i>		
HAAS CNC vertical	I machine #1	Memo	per folio FA917 & dwg , V: A-A -	0.00	, 10/06/24 10/06/29					<u>, </u>		PTÖ

2-Deburr as required

STEP	PROC							
		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto		
						,		
D 30	PAR #:	_ Fault Ca	itegory: wpch; n; ng	NCR: Ye	s No Dg	A:	Date: _	10cA08
R	esolution: Scy No	_ Disposit	tion: <u>Sermo</u>	_ QA: N/C	Closed:		∠ Date: ∠	007.08
1436	We	ORK OR	DER NON-CONFORM	ANCE (N	CR)			
STEP	Description of NC Section A	Initial Chief Eng	Action Description	Sig	ા& ∣ _{Sec}		Approval Chief Eng	Approva QC Inspecto
116	are too of 100" operator longer to remesure the tool This was the Occo wice cem A-A.		destroy and replace Butch # MII33/D Q1		/29 MV	/	Josune	10:003
				F				
	R 3436	Resolution: Scyns We STEP Description of NC Section A I part Scrap the thickness are too bout 100" exerctor longer to remessure the tool This was the second A.A.	Resolution: Scyno Disposit WORK OR STEP Description of NC Section A Initial Chief Eng I part Scrap the thickness are too book 100" operator Longet to remesure the tool This was the operator	Resolution: SCYND Disposition: Device WORK ORDER NON-CONFORM WORK ORDER NON-CONFORM Corrective Action Section A Initial Action Description Chief Eng I part Scrap the thickness are too body. 100" eperator Longet to remesure the tool This was Heaster wicke alim A-A. In 100 Action Description Chief Eng Action Description Chief Eng Authority and replace Butch # MII33/D MII33/D	Resolution: SCYND Disposition: DCND QA: N/C WORK ORDER NON-CONFORMANCE (NO STEP Description of NC Section A Corrective Action Section B Initial Action Description Chief Eng Da I part Scrap the thickness are too body. 100". eperator Longet to remeasure the tool Longet to remeasure the tool Initial Action Description Chief Eng Da Mare too body. 100". eperator Longet to remeasure the tool Initial Action Description Chief Eng Da Mare too body. 100". eperator Longet to remeasure the tool Mare too body. 100". eperator Longet to remeasure the tool Mare too body. 100". eperator Longet to remeasure the tool Mare tool and the color of the	Resolution: Scyns Disposition: Scyns QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A Corrective Action Section B Initial Action Description Chief Eng Chief Eng Date Ipart Scrap the thickness are too body. 100". eperator Initial Action Description Chief Eng Chief Eng Date Section A Chief Eng Chief Eng Date Whit was sheered in the tool This was sheered in the tool This was sheered in the tool WORK ORDER NON-CONFORMANCE (NCR) Initial Action Description Chief Eng Chief Eng Date Weriff Section B Veriff Section B Veriff Section B Whit was sheered in the tool This was sheered in	Resolution: Scription: Disposition: Device QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A Corrective Action Section B Initial Action Description Chief Eng Date Ipart Script the thickness are too wife 100" spendor And the tool Section B Ipart Script the thickness Action Description Chief Eng Date Initial Action Description Sign & Date Ipart Script the thickness Action Description Chief Eng Date Initial Action Description Sign & Date Ipart Script the thickness Action Description Section Date Initial Action Description Sign & Date Initial Action Description	Resolution: Scrus Disposition: Device QA: N/C Closed: Date: 1986 WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Corrective Action Section B Section A Section A Section Section B Initial Action Description Chief Eng Date Order Eng Date Orde

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Work Ord Friday, June 04,											7	Page 2
tem ID:	D3911-3		•	Accept				s	etup	Start		
Item Name:	Aft Eyebolt Re	eceiver			1			,	1	Stop		
Start Date: Required Date: Reference:	6/4/2010 6/10/2010	Start Qty: 20.00 Req'd Qty: 20.00	1881 1891 881 1881 1891 881		Cust Item I	D:	 					
Approvals:	Process Pla	n:	Date:	Tooling:	Da	nte:	1	R	lun	Start		
•			Date:	_ SPC (Y/N):		ite:				Stop		
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID		Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
QC Quality Control		QC2- Inspect parts off ma	chine FAI/FAIB	0.00	10/06/29			10	- P		:	<u>.</u>
130 QC Quality Control		QC8- Inspect parts - secon	nd check	0.00	MD= /2010/20			10	 	<u>\$</u>		
140		Identify as per dwg & Sto	ck Location: 090	0.00				,		, /		

140 Packaging

Memo

0.00

Packaging

Dart Aerospace Ltd W/O: **WORK ORDER CHANGES** Approval Chief Eng / Approval DATE STEP PROCEDURE CHANGE By Date dty QC Inspector Prod Mgr Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: _____ Resolution: _____ Disposition: ____ QA: N/C Closed: ____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	OTED	Description of NC		Corrective Action Section B		Verification		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
								,

Work Ord Friday, June 0											Page 3
Item ID: Revision ID:	D3911-3			Accept					Setup		ı isasilei dinin ist iləl ibbi
Item Name: Start Date: Required Date Reference:	Aft Eyebolt I 6/4/2010 e: 6/10/2010	Start Qty: 20.00 Req'd Qty: 20.00	1881 4 1871 88 1841 4 1841 48		Cust İtem I Customer:	D:				Stop	
Approvals:	Process Pl		Date:	Tooling: SPC (Y/N):		nte:			Run	Start Stop	
Sequence ID/ Work Center 150 QC QC Quality Control		Operation Description QC21- Final Inspection - Memo	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Re Qt	T	Reject Insp. Number Stamp Olo 30 H MW

10-6-30

Dart Aerospace Li

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W/O:			V	VORK OR	DER CH	ANGES		-	1		
DATE	STEP	P	ROCEDURE CI	HANGE			Ву	Date ·	зу	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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						•					
Part No	•	PAR #:	Fault Ca	itegory:	1	NC	R: Yes I	lo DQA:		Date:	
	R	esolution:	Disposit	tion:		QA	: N/C Clo	sed:	<u> </u>	Date:	
NCR:			WORK OR	DER NON	-CONFC	PRMANCE	E (NCR))			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Correctiv Acti	on Descrip	Section B	Sign &	Verificat Section		Approval Chief Eng	Approval QC Inspector
			Office Eng		Chief Eng		Date			,	
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											•
		,									
NOTE										·	

Picklist Print

Friday, June 04, 2010 10:23:40 AM

Work Order ID: 59436

Parent Item: .

D3911-3

Parent Item Name:

Aft Eyebolt Receiver

Comments:

IPP RevA: New issue DD verified by:EC

AS PER REV B 10-03-23 JLM VERIFIED BY:DD

IPP REV:B

Start Date: 6/4/2010

Start Qty: 20.00

Required Date: 6/10/2010

Required Qty: 20.00

Component Item ID/ Item Name M303B2.000X1.750

Replacement Mfg/ Item ID

Purch Purchased Item No

Primary Location Last Location

Route Seq ID 100

Unit of Measure f

Qty on Hand 0.5862

Loc Code

Qty per Kit Total

Otv 0.26 5.473684

Issued

Qty

Date Status Issued

Page 1

303 BAR 2" X 1.750"

Location

MAT53

113310

Loc Qty

0.5862 0.5862

2.4066 S. 8 10/06/28

Dart Aerospace	Ltd	
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W/O:			V	VORK ORDER CHANG	ES			+		1
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qу	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		esolution:								
NCR:		T		DER NON-CONFORM						
DATE	STEP	Description of NC	1-:4:-1		tion B	0: 0	Verifica	tion	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	59.436
Description: Aft Eyebolt Receiver	Part Number:	D3911-3
Inspection Dwg: D3911 Rev: C		Page 1 of 1

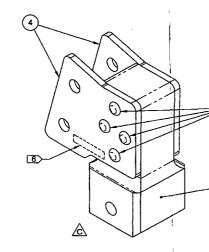
FIRST ARTICLE INSPECTION CHECKLIST

Drawing	Tolerance	Actual	Accept	Reject	Method of Inspection	Comments
Dimension		Dimension	-		inspection	
1.250	+/-0.010	1.248				
1.250	+/-0.010	1.248				
0.09 X 45°	+/-0.030 X 0.5°	085 X 45°				
1.00	+/-0.030	1.000	_/			
0.500	+/-0.010	500				
R0.13	+/-0.030	R.125	/			
Ø0.129	+0.005/-0.001	Ø.129				
R0.19	+/-0.030	R.190	/			
0.960	+/-0.010	963	_/			
0.09 X 45°	+/-0.030 X 0.5°	.095×45°				
Ø0.257	+0.006/-0.001	8.260				
0.350	+/-0.010	-349				
2.76	+/-0.030	2.760				
1.110	+/-0.010	1.110				
0.800	+0.000/-0.010	745			-	
0.225	+/-0.010	.225				
1.80	+/-0.030	1.799				
0.65	+/-0.030	. 6/00				
0.625	+/-0.010	. 421				
0.09 X 45°	+/-0.030 X 0.5°	120 X45°				
Ø0.734	+0.010/-0.000	8.736				
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			-			

-Measured-by:-	- Onl	Audited by:	mo-	Preliminary Approval:	
Date:	10/06/29	Date:	10/04/30	Date:	

Rev	Date	Change	Revised b		Approved
A	10.06.07	New Issue	KJ C	PLA	
				171	•

		•		1 '	,
	ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
		X		D3911-041	BASKET INSTL STUD ASSY (LOWER)
			X	D3911-043	AFT EYEBOLT RECEIVER ASSY
	1	1	 -	D3911-1	BASKET INSTL STUD (LOWER)
	2		1	D3911-3	AFT EYEBOLT RECEIVER
D	3	2		D3911-5	BASKET STUD PLATE
	4		2	D3911-7	BASKET PLATE-EYEBOLT RECEIVER
	5	3	4	MS20615-4M20	RIVET



SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER

D3911-043 AFT EYEBOLT RECEIVER ASSY

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С

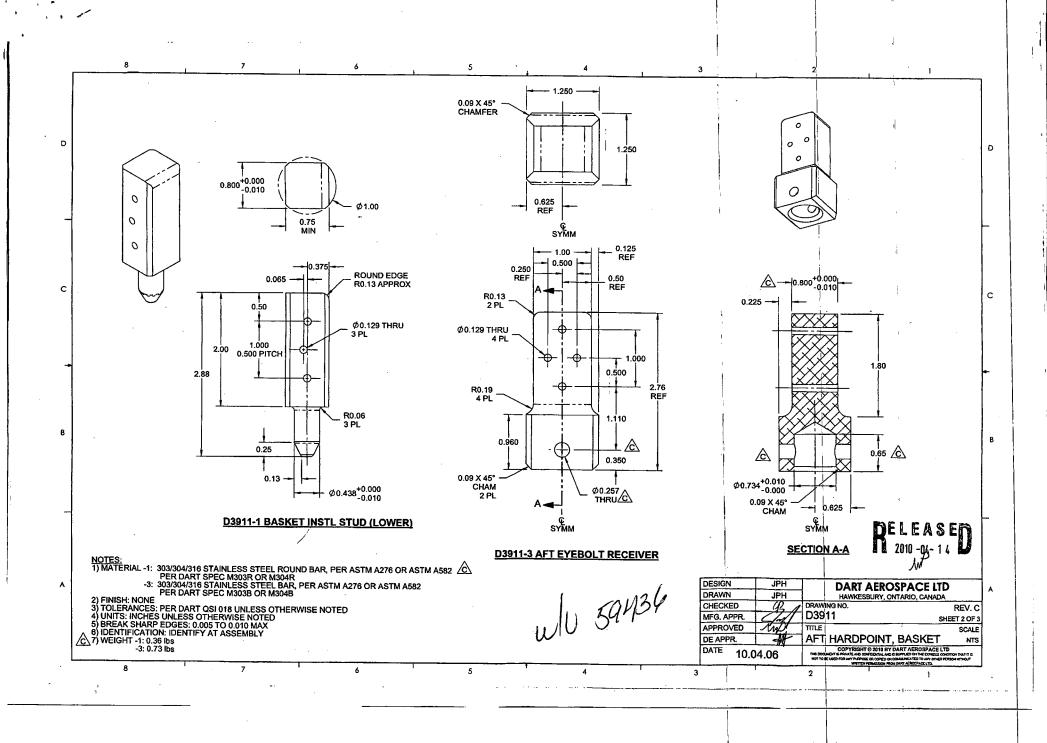
DESIGN		JPH	DADT AEDOCD	AMEL	-
REV.		D	BY DATE		
A	NEW ISSUE			JPH	10.03.04
B DIAMETER (B3-2) AND D		ER (83-2) AND D	IM ADDED (B2-2) & (C3-2)	JPH	10.03.16
С	-043 ASS D3911-0 ADDED	SY. WEIGHT UPO 43 & D3911-3 DE TO NOTES (SHT	MS21209-C610 REMOVED FROM DATED. D3911-3 REDESIGNED. TAIL UPDATED. MTL SPEC 2). DIM 0.375 WAS 0.400 (C3-3).	JPH	10.04.06

DESIGN	JPH	DART AEROSPACE	ITD
DRAWN	JPH	HAWKESBURY, ONTARIO, CAN	
CHECKED	1 100	DRAWING NO.	REV. C
MFG. APPR.	Chil	D3911	SHEET 1 OF 3
APPROVED	LW,	TITLE	SCALE
DE APPR.	-144-	AFT HARDPOINT, BASKE	T nts
DATE 10.0	04.06	COPYRIGHT © 2018 BY DART AEROSPA:	ESS CONDITION THAT IT IS

D3911-041 BASKET INSTL STUD ASSY (LOWER)

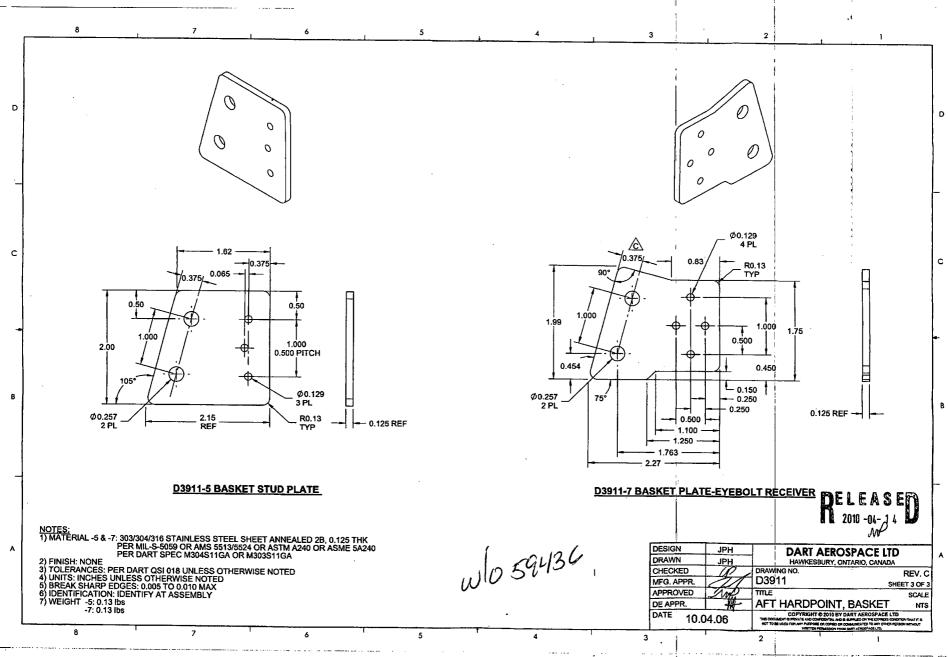
NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N D3911-04X USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -041: 0.63 lbs

W/O:				WORK ORDER CH	HANGES					t
DATE	STEP	PI	PROCEDURE CHANGE By Da						Approval Chief Eng / Prod Mgr	Approval QC Inspector
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				Fault Category: NCR: Yes No D					_ Date:	
	R	esolution:		_ Disposition: QA: N/C Closed:						
NCR:			WORK O	RDER NON-CONF	ORMANCE	(NCR)				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Descri	Section B ption	Sign & Date	Verification C	n	Approval Chief Eng	Approval QC Inspector
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Part No: PAR #:		Fault Ca	tegory:	_ NCR	: Yes I	lo DQA:				
Resolution:			Disposit	ion:	_ QA:	N/C Clo	sed:	1	Date:	
NCR:		V	WORK OR	DER NON-CONFORMA	NCE	(NCR)				
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Description	on B	Sign &	Verificat Section		Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng		Date		-		
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Dart Aerospace Ltd	D	ar	t a	A	er	O	S	p	a	C	е	L	to	d
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W/O:			W	ORK ORDER CHANG	ES			1	<u> </u>	• •
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Part No: PAR #: Resolution:										
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DATE	CTED	Description of NC		Corrective Action Sect	ion B		Verificat		Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	<u> </u>	Chief Eng	QC Inspector
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NOTE: D	ate & initia	al all entries					<u> </u>	-	<u> </u>	